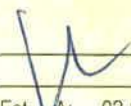



Date Thursday, 16/08/2007 11:31:57 AM  
 User Linda Lacelle

## Process Sheet

SPHIT-1

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STEP EXTRUSION
Job Number	: 34016 -1		
Estimate Number	: 10058		
P.C. Number	: N/A	Part Number	: D2622120C
This Issue	: 16/08/2007 S.O. No. : N/A	Drawing Number	: D2622 REV C1
Previous Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : PURCHASED PARTS	Drawing Revision	: C1
Previous Run	: 32858	Material	: N/A
Written By	: 	Due Date	: 10/09/2007
Checked & Approved By	: 	Qty:	121 <del>110</del> Um: Each
Comment	: Est. N/A: 02.11.12 New Issue KJ/RF		

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0

PG

PURCHASING



Comment: PURCHASING

Issue P/O: 4375

C207106/116

(110)

- a) Extrude as per Dwg D2622 Rev. C
- b) Material: 6061-T6 (QQ-A-200/8)
- c) Minimum yield tensile strength = 35 ksi
- d) Minimum ultimate tensile strength = 38 ksi
- e) Minimum elongation = 8%
- f) Order at 120" longg) Bon L Canada Inc. tool # 897123 Rev. A
- h) To be packed per DSK 066
- i) Pull test to ASTM standard B221 required.
- j) Material certification is required

2.0

D2622120CP

Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 110.0000 Each(s)  
 Extrusion

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage  
 Ensure material certification is attached

C21425

(132)

4.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimension per Dwg D2622  
 Check Pull test per Dwg D2622 for compliance page attached  
 Check hardness with Webster tester

10709-06

(132)

C21425

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: D Date: 07/09/19  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Date: Thursday, 16/08/2007 11:31:57 AM

User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP EXTRUSION

Job Number: 34016

Part Number: D2622120C

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA

Q.M 07-09-19

(90)

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07-09-19

Job Completion



W 07-09-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

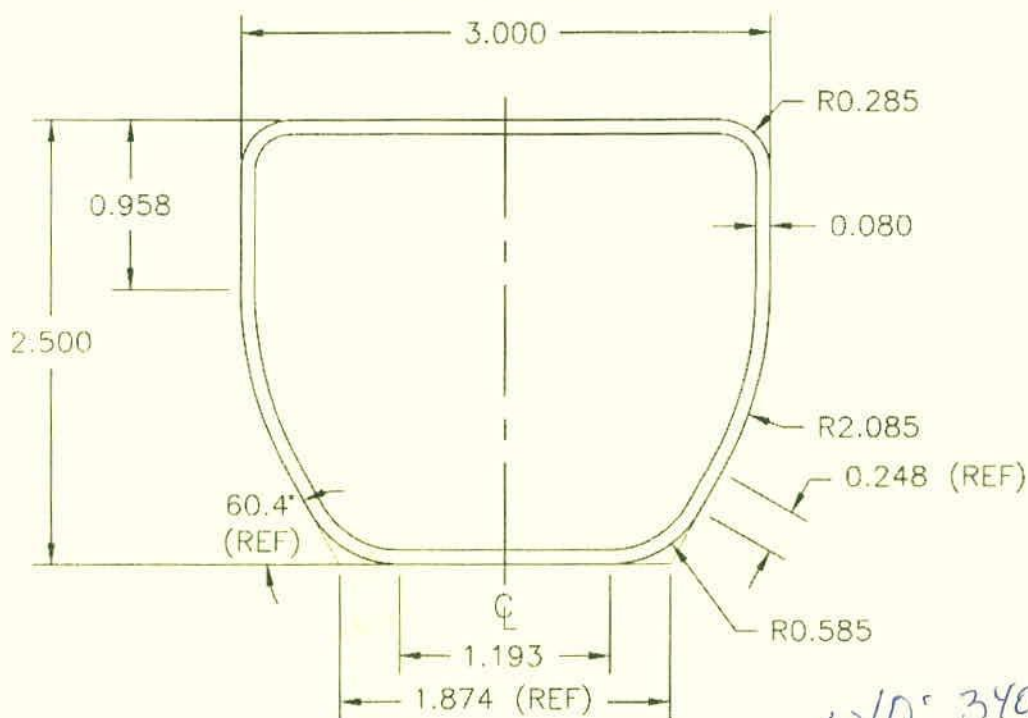
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**DART**

DESIGN	KE	DRAWN BY	GP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	JH	APPROVED	JH	DRAWING NO. D2622	REV. C SHEET 1 OF 1
DATE	02.09.11			TITLE STEP EXTRUSION	SCALE 1:1
A	96.11.29			NEW ISSUE	
B	97.12.12			CHANGE MATERIAL, ADD TOL. QSI	
C	02.09.11			0.080 WAS 0.085; ADD PART & DIE No.	
CI	02.10.04			ADD 'REV A' TO DIE NUMBER	



#### D2622-XXX STEP EXTRUSION

- 1) PART NUMBER IS D2622-XXX WHERE 'XXX' IS CUT LENGTH IN INCHES (EG. D2622-120 IS 120" LONG)
- 2) MATERIAL 6061-T6 (QQ-A-200/8)
- 3) MANUFACTURED USING BON-L DIE # 897123 Rev. A
- 4) A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE MINIMUM MECHANICAL PROPERTIES STATED BELOW:

MINIMUM TENSILE YIELD STRENGTH = 35 ksi  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi  
MINIMUM ELONGATION = 8%

- 5) PART IS SYMMETRIC ABOUT CENTERLINE
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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**THE WILLIAM L. BONNELL COMPANY, INC.**  
**BON L MANUFACTURING COMPANY**  
 SUBSIDIARIES OF TREDEGAR CORPORATION  
 FILIALES DE LA CORPORATION TREDEGAR

BOH L CANADA INC  
500 EDWARD AVENUE  
RICHMOND HIL ON L4C 4Y9

## MANIFEST DATE/DATE D'EXPÉDITION

1850-1851

MANIFEST NUMBER/N° D'EXPÉDITION

INDEX

SALES ORDER NUMBER/N° DE COMM.

80904

REFER TO  
THESE NUMBERS ON  
ALL CORRESPONDENCE.  
RÉFÉREZ-VOUS À CES  
NUMÉROS POUR TOUTE  
CORRESPONDANCE.

CREDIT REP  
REP. DU CRÉDIT  
905-508-3250

SALES REP
REP. DES VENTES

FIELD SALES REP  
REP. RÉGIONAL DES VENTES

CUST SERVICE REP	
REP. SERVICE CLIENTELE	

$$e^{-50} = 3.7 \times 10^{-22}$$

905-427-2227

SHIP TO/EXPÉDIÉ À

SOLD TO/VENDU À

ART AEROSPACE LTD.  
270 ABERDEEN ST.  
HAWKESBURY  
6A 1K7

DAVE PEROSPE LTD.  
1275 ABERDEEN ST.

ON FRAKESBURY

034 124 117

PHONE 613-632-3200

PHONE 513-332-5200

CUSTOMER ID/N° DU CLIENT

ORDER DATE

CUST. P.O. NO./N° DE COMM. DU CLIENT

JOB/PROJET	
------------	--

BILL OF LADING NUMBER/N° DE CONNAISSEMENT

46024

08/16/07

4375

0035495

[illegible]







# CERTIFICATE OF COMPLIANCE

## BON L CANADA INC

500 EDWARD AVENUE  
RICHMOND HILL, ON L4C 4Y9

Cert. Date	Cert. No.	Sales Order	Page
08/28/07	165105	82904	1
Cust. PO	B/I. No.	Lot	Date
4375	00355495	82904010	8/28/07

Sold To	Ship To
46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7	46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7

Item No.	Part No.	Item Description	Cust Part
1.000	DAA-897123-1	120" Mill 6061 T6	D2622

Gross Weight	578 KGS
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Net Qty	536 KG	132 PC	402 M	3 PKG
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Specification	Die Deso
AMS-QQ-A-200/8 & ASTM B221-00	

### Mechanical Tests:

Test No.	Tensile MPA / KSI	Yield MPA / KSI	%Elongation	Conductivity	Bend/ Drift HREW
1	314.5 / 45.6	271.8 / 39.4	12.1	.0	95

### Chemical Analysis:

SI	FE	CU	MN	MG	CR	NI	ZN	GA	V	TI	ZR	OTHER
.67	.25	.29	.06	.91	.07	.000	.04	.000	.008	.02	.000	.00
.00	.00	.00	.00	.00	.00	.000	.00	.000	.000	.00	.000	.00
.00	.00	.00	.00	.00	.00	.000	.00	.000	.000	.00	.000	.00

This will certify that the material described herein has been inspected and tested in accordance with Bon L Canada's standard sampling and testing procedures or in accordance with the requirements of any specifications forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

D. VanBakel, QA Manager Signed for Bon L Canada

